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RBW1205G00332-3G

Job Sheet 195386



Part No: RBW1205G00332-3G **Job Qty:** 2 pcs

Part Name: Main Gear Box Oil Draining Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/21/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	6/21/19		0.00	2.67	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	6/21/19		0.00	0.00	QC 5 - 10		DAS 40 JUN 12 2019 9:50
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	2 pcs	6/21/19		0.00	0.00	Packaging 3 - 1 - B4B		MLL
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		
							Packaging 3 - 18 - B4B		



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Container No: S189787



Part: RBW1205G00332-3G

Job No: 195386

Serial No/Batch: S189787

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 06/12/19

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				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
140 QC 21 - FG	2 pcs	6/21/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	9-55
				QC 21 - SA - 53	

Part Op 100 - Small Fab - 1-Cut 9657K135 (-25) spring to 0.5" as per work order deviation 2-Assemble as per DWG sheet 1.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location;
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1315	Crimp Hose Clamp 9/16"	2 pcs (1 ea)	100-Small Fab - 1	5038400
2619	Spring Rnd 3/4"	2 Ea (1 ea)	100-Small Fab - 1	5075015
4464T123	O-Ring 9/16 Od X 1/16 Cross	2 Ea (1 ea)	100-Small Fab - 1	5049527
91665A350	Retaining Ring, 7/16" Shaft	2 Ea (1 ea)	100-Small Fab - 1	5046009
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	12 ft (6 ea)	100-Small Fab - 1	5159561
RBW1205G00332-3G-01	Cap	2 pcs (1 ea)	100-Small Fab - 1	5137030
RBW1205G00332-3G-03	Quill	2 pcs (1 ea)	100-Small Fab - 1	5139008
RBW1205G00332-3G-17	Sleeve	2 pcs (1 ea)	100-Small Fab - 1	5136972
RBW1205G00332-3G-19	Barb	2 pcs (1 ea)	100-Small Fab - 1	5110398
RBW1205G00332-3G-21	Valve	2 pcs (1 ea)	100-Small Fab - 1	5137144
RBW1205G00332-3G-23	Screw (Modified B/O)	4 pcs (2 ea)	100-Small Fab - 1	5103948
RBW1205G00332-3G-24	End Cap	2 pcs (1 ea)	100-Small Fab - 1	5137017
9657K135	Spring	2 Ea (1 ea)	100-Small Fab - 1	5047012

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	1315	2	47	0
	2619	2	29	0
	4464T123	2	36	0
	91665A350	2	8	0
	9657K135	2	7	0
	K010-0608	12	381	0
	RBW1205G00332-3G-01	2	8	0
	RBW1205G00332-3G-03	2	12	0
	RBW1205G00332-3G-17	2	4	0
	RBW1205G00332-3G-19	2	10	0
	RBW1205G00332-3G-21	2	9	0
	RBW1205G00332-3G-23	4	1	0
	RBW1205G00332-3G-24	2	8	0

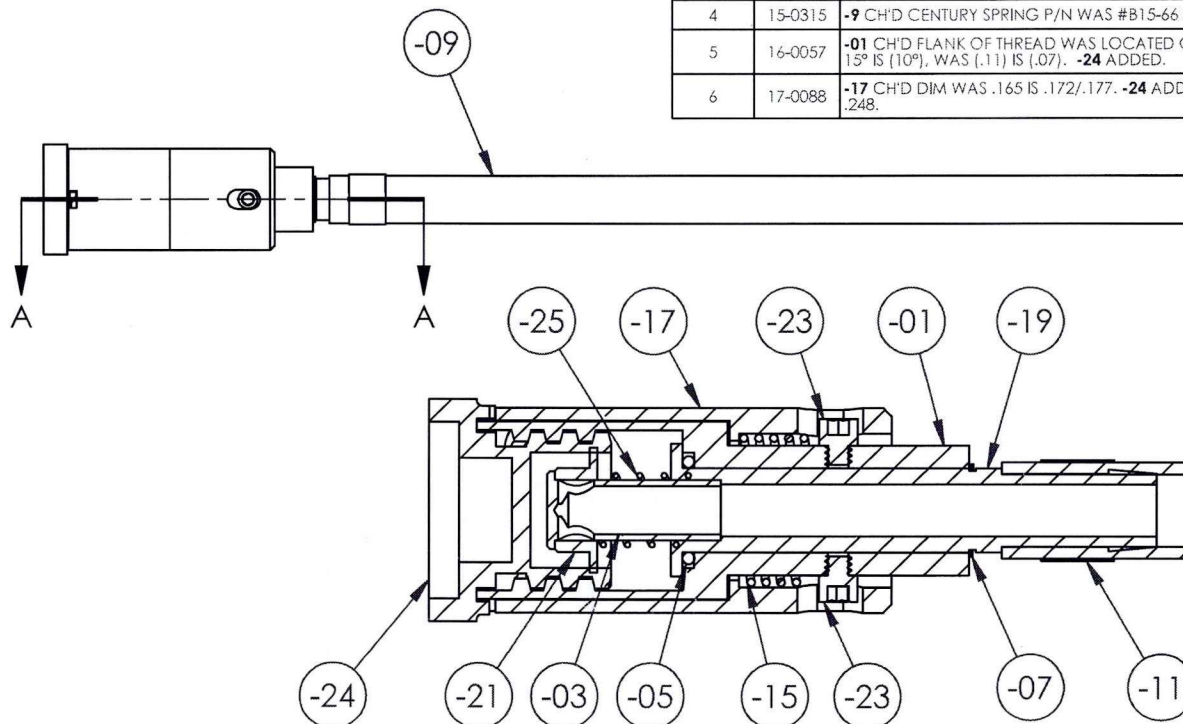
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED WITH SHUTOFF AND RETAINING SLEEVE, ADDED PARTS -03, -17, -19, -21 & -23.	3/2/2011	JAG	
2		-01 CH'D TO CLEAR ANODIZE, THREAD CORRECTED TO 13/16-6. -03 CH'D HOLE FROM Ø.20, CH'D LIMIT DIM FROM Ø.3135-.3139. -17 CH'D TO CLEAR ANODIZE. -19 CH'D HOLE DIA. FROM Ø.26 AND .10 FLANGE TO .06. -21 CH'D Ø.313 TO LIMIT DIM S.F.	11/30/2011	RJC	DW
3		-17 ADDED ENGRAVE NOTE. -23 CH'D O.D. FROM Ø.20 TO Ø.200 +.003 -.000.	2/15/2012	RJC	SE
3A		-13 DELETE, ENGRAVING IS ON -17.	5/2/2013	RJC	RJC
4	15-0315	-9 CH'D CENTURY SPRING P/N WAS #B15-66 IS #2619.	9/30/2015	RJC	JAG
5	16-0057	-01 CH'D FLANK OF THREAD WAS LOCATED ON CENTERLINE IS OFFSET 13° FROM CENTERLINE; WAS 15° IS (10°). WAS (.11) IS (.07). -24 ADDED.	6/16/2016	SM	JAG
6	17-0088	-17 CH'D DIM WAS .165 IS .172/.177. -24 ADDED DIM'S .696, Ø1.09, MIN. R. DELETED DIM'S 2X .068, .248.	4/17/2017	RJC	JAG



SECTION A-A
SCALE 1 : 1

NOTE:
FUNCTION: PART OF HELICOPTER SERVICING KIT PART No 3G1205G00131. USED TO DRAIN OIL FROM THE MGB THROUGH THE PARKER STRATOFLEX COUPLING, RBW1205G00332-3G REPLACES STRATOFLEX (11362) (A3Q07) P/N 165006.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-01	1	CAP	6061		2
			-03	1	QUILL	303/304 S.S.		3
		B/O	-05	1	O-RING	BURNA-N	9/16 OD X 1/16 CROSS (MCMaster-CARR #4464T123)	1
		B/O	-07	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT MCMaster-CARR #91665A350	1
		B/O	-09	1	HOSE	VINYL	Ø1/2 X 3/8 X 6 FT. KURI-TECH #K010-0608	1
		B/O	-11	1	CRIMP HOSE CLAMP	S.S.	Ø1/2 DIXON VALVE #OET-1315	1
		B/O	-15	1	SPRING	SPRING STEEL	Ø3/4 CENTURY SPRING #2619	1
			-17	1	SLEEVE	6061		4
			-19	1	BARB	303/304 S.S.		5
			-21	1	VALVE	303/304 S.S.		6
			-23	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	7
			-24	1	END CAP	6061		8
		B/O	-25	1	SPRING	MUSIC WIRE	Ø.028 WIRE: Ø.360 OD X .5 FREE LENG RIED #S1165	1



MAIN GEAR BOX DRAIN TOOL

DWG NO. RBW1205G00332-3G

REV 6

MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	FINISH	DIMENSIONS ARE IN INCHES	FRACTIONS ± 1/8
		.XXX ± .005	ANGLES ± 1/8°
		.XX ± .01	SURFACES = 125°
		.X ± .1	
SPEC		1. BREAK ALL SHARP EDGES	
DRAWN BY: PERRITT		.015 x 45° OR .015R	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY	
OPPS APPR: ANDERSON		AFTER PLATING	
QA APPR: LINDSAY		3. INTERPRET DIM AND TOL PER	
APPROVED: GILBERT		ASME Y14.5M-2009	
SCALE 1:2		USED ON MODEL	
DATE 2/23/2011		AGUSTA	
		SHEET 1 OF 8	